

Date: Thursday, 6/21/2007 2:29:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B HIGH GEAR WEB
Job Number	: 33060		
Estimate Number	: 10455		
P.O. Number	: N/A	Part Number	: D26543
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D2654 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: E1
Previous Run	: 32622	Material	: N/A
Written By	: <u> </u>	Due Date	: 7/10/2007 Qty: 5 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	B-29985

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

07/07/30 AWM

④10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/07/30 (x5)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

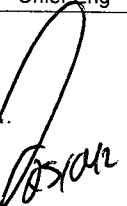



Chemical Conversion Coat as per QSI 005 4.1

JD 7-8-1

⑤

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/28/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/01/07	23	one in web 2654-3 scrap due to dull carbide. all 6.5mm holes are ovalized / out of round		Scrap and destroy and replace. Tell employees to disregard the throw out dull bits.	07/01/07 AWH				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 33060

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EN 07/08/02 (5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP

7-8-4

(5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)
D 07/08/07

Job Completion



C207/08/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

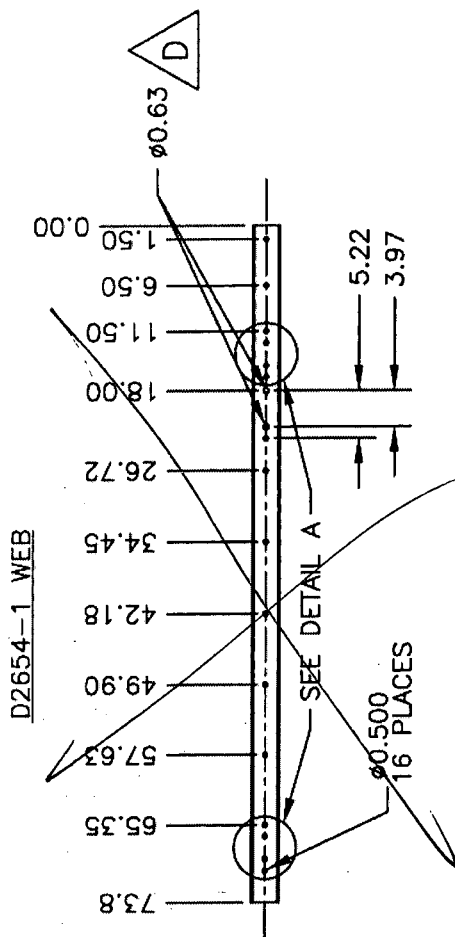
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

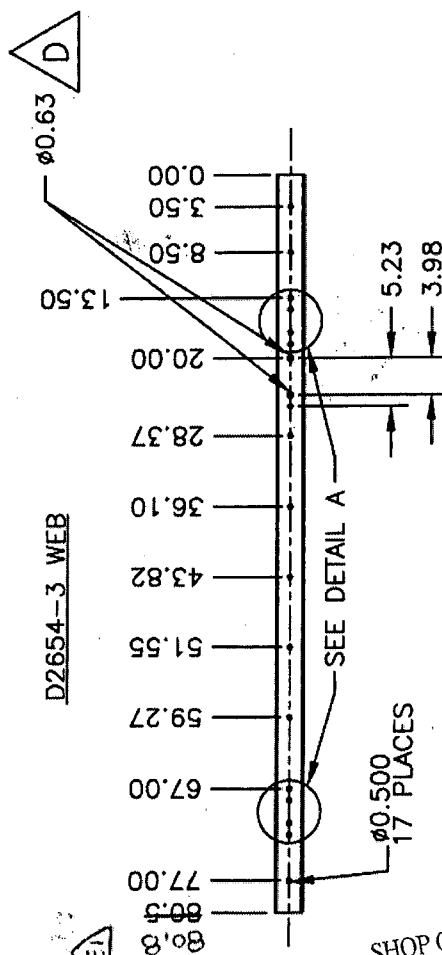
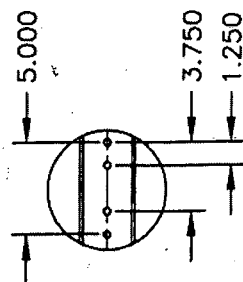


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				PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D2654
				REV. E SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE 1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	CP 04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22



DETAIL A
SCALE 1:10



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NO. 33060

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

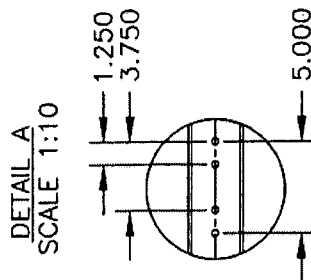
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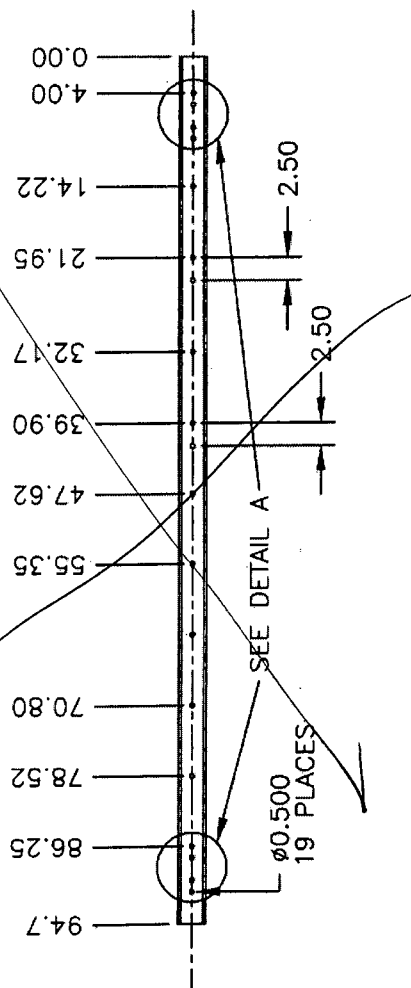


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB	SCALE 1:20	

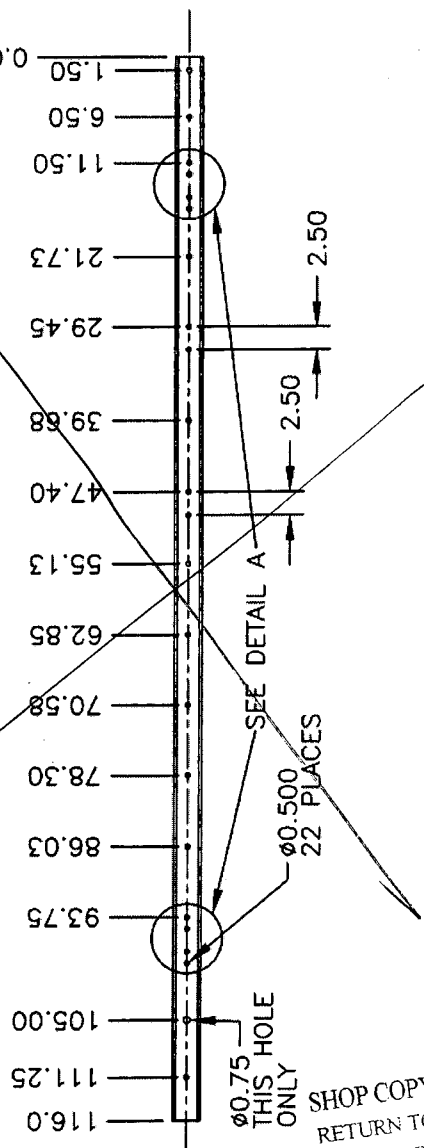
RELEASED
04.06.22



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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